



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C45-12-2

Job Sheet 173244



Part No: C45-12-2

Job Qty: 20 ea

Part Name: Lock Shaft



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/27/18

Job Tracking No:

Due Date: 3/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C45-12-2 Rev 3A IPP Rev A 18.02.08 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		3/15/18	0.00	0.00	Start Up Machining-4		3/18-2-28
120	CNC Lathe	20 pcs		3/16/18	0.50	2.00	MORI SL-154		1/2
130	QC	20 pcs		3/16/18	0.00	0.00	QC2 Machining-5		1/2
140	QC	20 pcs		3/16/18	0.00	0.00	QC8 Machining-5		2.18-03-01
150	Packaging	20 pcs		3/16/18	0.00	0.00	Packaging3-2		MAR 02 2018
160	QC21-SA	20 Ea		3/16/18	0.00	0.00	QC21		

Part Op 120 - 1- Machine as per folio FB851 FOLIO REV: _____ DWG REV: _____ 2- Deburr
Descriptions: 150 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H900-R0.625	17-4 SS H900 Round Bar 0.625"	3.0400 ft (.152 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H900-R0.625	14	0	

M17-4-H900 R0.750 45 2018-02-17

Part Specifications

Specifications could not be found.

Plex 2/27/18 11:28 AM Dart.lajeunesse.marie



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S046506



Part: C45-12-2

Job No: 173244

Serial No/Batch: S046506

Revision: 3A

Inspector:

Date: 02/28/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
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C45-12-2 can be manufactured from 17-4PH-H900 as an alternative material Heat treat and Nickel plating is not required if the part is manufactured from 17-4PH-H900				- This deviation is acceptable. - The drawing will be updated to reflect this change. - The fit, form and function of the part will be as originally intended.				Completed By																																																																											
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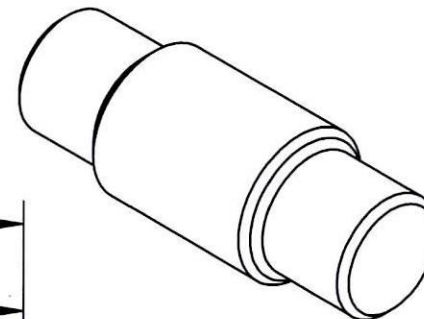
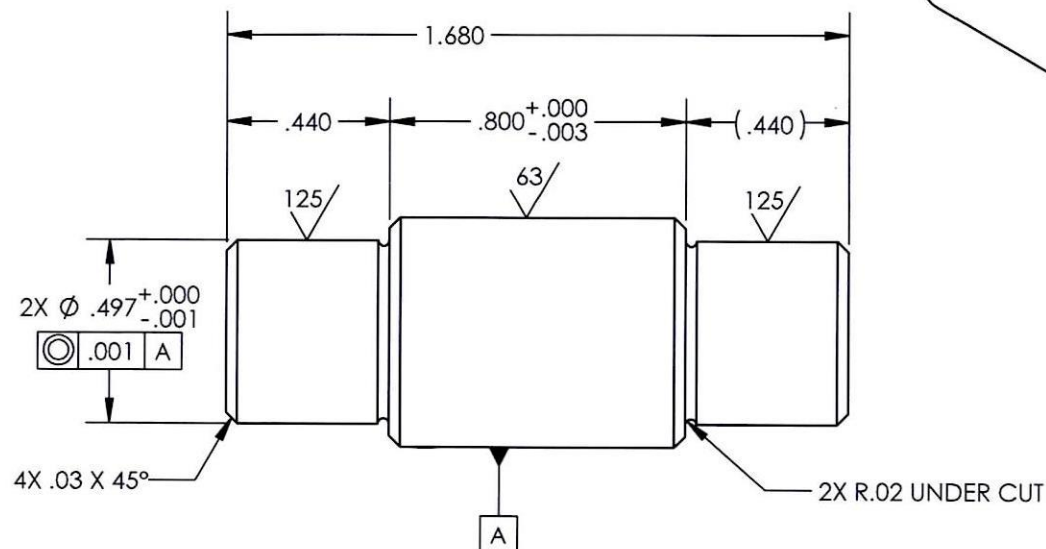
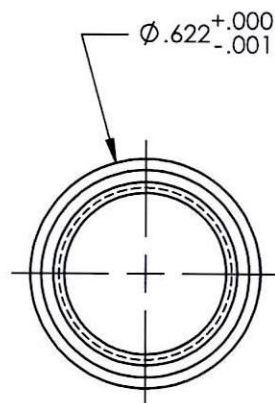
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3		AS DRAWN BY CANAM.	9/14/2012	JAG	
3A	14-0127	CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED BAG & LABEL NOTE. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	8/14/2014	DPD	RW



NOTES:

1. NICKEL PLATE .0004 - .0006, BAKE AFTER PLATING.
2. BAG & LABEL WITH BATCH NUMBER.

DART AEROSPACE	
TITLE LOCK SHAFT	
DWG NO. C45-12-2	REV 3A
MAT'L 4140/4142	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1	APPROVED <i>D Weil</i> HEAT TREAT 44-46 HRC FINISH SEE NOTE 1
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SPEC USED ON MODEL
SCALE 2:1	DATE 5/14/1997 SHEET 1 OF 1

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C45-12-2	1	LOCK SHAFT	4140/4142	Ø5/8 X 1-3/8

INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

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